

Work Order ID 73528

Thursday, September 01, 2011 2:45:03 PM



Page 1

Item ID: D350-588-011

Accept



Setup Start



Revision ID:

Item Name: Aft Door Fwd Hinge Modification

Stop



Start Date: 9/1/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev N/A

100



DC

Document Control

DOCUMENT CONTROL

10

0.00

Memo

0.00

Photocopy bluefile and create labels per PPP D350-588-011 CHG002

8

11 - 11 - 02

110



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

11/9/7 100

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

11 - 11 - 02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-588-011

Location: 22PPP Rev: C*CA/11/02**(102)*

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/11/02
msf
11-11-02

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Picklist Print

Thursday, September 01, 2011 2:44:59 PM

Page 1

Work Order ID: 73528

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification


Start Date: 9/1/2011

Required Date: 9/9/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:M:04.08.31 Added D2690-17:KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C1032R7		Purchased	No			120	Each	54.0000	2	20			
													
S40 Screw													

Location

Loc Qty

Loc Code

ST328

54

116304

54

120

Each

95.0000

8

AN526C832R8

Purchased

No



Screw

Location

Loc Qty

Loc Code

ST327

95

117688

3

117735

92

120

Each

296.0000

8

AN526C832R9

Purchased

No



Screw

Location

Loc Qty

Loc Code

ST327

296

117010

7

117628

89

118422

200

120

Each

0.0000

4

AN960JD10

NAS1149D0363J

Purchased

No



Washer

AN960JD8

NAS1149DN832J

Purchased

No



Washer

212x
M117316 M117887 11/9/8
(100)

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Thursday, September 01, 2011 2:44:59 PM

Page 2

Work Order ID: 73528

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 9/1/2011

Required Date: 9/9/2011

Start Qty: 10.00

Required Qty: 10.00

SAD
D2143
Hinge Bracket

Manufactured No

120

Each

19.0000

1

10

Location

Loc Qty

Loc Code

ST198

19

64308

19

Manufactured No

120

Each

7.0000

1

10

SAD
D2144
Hinge Bracket

-2

Location

Loc Qty

Loc Code

ST198

7

64778

7

Manufactured No

120

Each

26.0000

2

20

SAD
D2150
Packer Doubler, Hinge

Location

Loc Qty

Loc Code

ST006

26

69514

26

Manufactured No

120

Each

23.0000

2

20

SAD
D2151
Packer Doubler, Hinge

Location

Loc Qty

Loc Code

ST006

23

69515

23

Manufactured No

120

Each

33.0000

1

10

SAD
D2153
Door Prop

Location

Loc Qty

Loc Code

ST272

33

71003

33

Thursday, September 01, 2011 2:44:59 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: ~ _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, September 01, 2011 2:44:59 PM

Page 3

Work Order ID: 73528

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 9/1/2011

Required Date: 9/9/2011

Start Qty: 10.00

Required Qty: 10.00

D2154 Manufactured No 120 Each 23.0000
Stud Bracket

Location	Loc Qty	Loc Code
ST006	23	
64312	23	

D2237 Manufactured No 120 Each 23.0000
Striker Plate

Location	Loc Qty	Loc Code
ST009	23	
66139	3	
70558	20	

D2461 Manufactured No 120 f 113.6937 7.25
Neoprene "D" Seal

Location	Loc Qty	Loc Code
ST402	113.6937	
39782	6.5	
55054	4	
63880	103.1937	

cut 1 X 87.00"
D2463 Manufactured No 120 f 739.9248 7.25
Seal

Location	Loc Qty	Loc Code
ST404	739.9248	
64944	1.71	
66954	238.2148	
72232	500	

cut 1 X 87.00"

Thursday, September 01, 2011 2:44:59 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Thursday, September 01, 2011 2:45:00 PM

Page 4

Work Order ID: 73528

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 9/1/2011

Required Date: 9/9/2011

Start Qty: 10.00

Required Qty: 10.00

D2583 Manufactured No

120 Each

25.0000

2

20



Latch Bracket

Location

Loc Qty

Loc Code

ST017

25

70559

25

D2585 Manufactured No

120 Each

29.0000

2

20



Mounting Channel

Location

Loc Qty

Loc Code

ST017

29

70814

29

D2586 Manufactured No

120 Each

48.0000

2

20



Door Latch

Location

Loc Qty

Loc Code

ST204

48

70557

48

D2587 Manufactured No

120 Each

6.0000

1

10



Door Slug, 350 Hinge

Location

Loc Qty

Loc Code

ST017

6

66836

6

D2589 Manufactured No

120 Each

72.0000

1

10



Keys, Key Chain, 350 Hinge

Location

Loc Qty

Loc Code

ST018

72

58194

72

Thursday, September 01, 2011 2:45:00 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Thursday, September 01, 2011 2:45:00 PM

Page 5

Work Order ID: 73528

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 9/1/2011

Required Date: 9/9/2011

Start Qty: 10.00

Required Qty: 10.00

S
710
D2690-17



Cable

Manufactured No

120

Each

11.0000

1

10

Location

Loc Qty

Loc Code

ST020

11

66510

11

S
410
D2857-1



Hinge Bracket

Manufactured No

120

Each

8.0000

1

Location

Loc Qty

Loc Code

ST024

8

66983

8

S
410
D2857-2



Hinge Bracket

Manufactured No

120

Each

28.0000

1

Location

Loc Qty

Loc Code

ST024

28

65091

4

67001

24

S
410
D2858-1



Hinge Bracket

Manufactured No

120

Each

23.0000

1

Location

Loc Qty

Loc Code

ST024

23

69595

23

S
410
D2858-2



Hinge Bracket

Manufactured No

120

Each

21.0000

1

Location

Loc Qty

Loc Code

ST024

21

69594

21

Thursday, September 01, 2011 2:45:00 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC, Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, September 01, 2011 2:45:00 PM

Page 6

Work Order ID: 73528

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 9/1/2011

Required Date: 9/9/2011

Start Qty: 10.00

Required Qty: 10.00

FG-778150-550-ROL

Purchased

No

120

sf

2,276.811

1

10



7781 9oz Glass 50"x125yd



sf

Location

Loc Qty

Loc Code

CA

1300.811

117602

1300.811

10x

ST404

976

104845

3

108932

18

111166

392

113905

563

S 40

1- cut 1 squarre ft of glass cloth

MS20426AD3-4

Purchased

No

120

Each

5,028.000

12

120



RIVET



sf

Location

Loc Qty

Loc Code

ST316

5028

104374

1122

110398

3906

120

MS20470AD4-5

Purchased

No

120

Each

3,026.000

18

180



Rivet, Universal Head



11 6/28

120

Location

Loc Qty

Loc Code

ST319

3026

116893

134

118405

2895

115
65

Thursday, September 01, 2011 2:45:00 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC, Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Thursday, September 01, 2011 2:45:00 PM

Page 7

Work Order ID: 73528

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 9/1/2011

Required Date: 9/9/2011

Start Qty: 10.00

Required Qty: 10.00

MS21042L08

Purchased

No

120

Each

602.0000

18

180



Nut

Location

Loc Qty

Loc Code

ST300

602

117739

8

118451

100

118628

494

MS21042L3

Purchased

No

120

Each

1,749.000

4

40



Nut

Location

Loc Qty

Loc Code

ST300

1749

117441

132

117601

400

117885

217

118451

1000

MS27039-08-11

Purchased

No

120

Each

155.0000

2

20



Screw

Location

Loc Qty

Loc Code

ST290

155

116289

5

117441

150

MS27039-1-15

Purchased

No

120

Each

118.0000

2

20



Screw

Location

Loc Qty

Loc Code

ST292

118

118093

25

118574

93

Thursday, September 01, 2011 2:45:00 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00